

Aero Design Ltd.

Work Order Control Sheet

Work Order#: 2015-11 Date Opened: 23 Jan 2015 Title: Assembly

Aircraft OEM: Eurocopter Aircraft Model: AS350/355 Product Type: Cargo Basket Product Model: Ski Quantity: 1

Work Order Contents

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

JR
N/A
JR
JR
N/A
JR
N/A
N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

JR
JR

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94023	0	Mount Hoop	JR
94010	1	Basket	JR
94011	0	Body	JR
94012	0	Lid	JR
94027	0	Data Plate	JR

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

JR
N/A
N/A
N/A
N/A

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JR
N/A
JR

Traveller

Install walkway on lid
Install lid on basket body
Re-tap mounting lug holes and install mount lugs
Install handle brackets
Install handle
Install lid prop
Install data plate

Initial or N/A

MR
MR
MR
MR
MR
MR
MR

Work performed by:

Print: J Rekve for M Rekve

Sign: [Signature]

SCA: AD01

Date: 29-Jan-15

ICC / Dual Inspection performed by:

Print: Jeff Clarke

Sign: [Signature]

SCA: AD02

Date: 29-Jan-15

Work Order closed by:

Print: Jason Rekve

Sign: [Signature]

SCA: AD01

Date: 30-Jan-15

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014

1. Approving Civil Aviation Authority/Country Transport Canada		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No.
4. Organization Name and Address AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3				5. Work Order/Contract/Invoice WO2015-11	
6. Item	7. Description	8. Part Number	9. Qty.	10. Serial/Batch No.	11. Status/Work
	Cargo Basket	94010-01	1	94001-40	New
12. Remarks Modified with walkway on lid IAW DCL704					
13a. Certifies that the items identified above were manufactured in conformity to:			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12		
<input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature <i>Jeff Clarke AD02</i>		13c. Approved Organization Number AMF 73-04		14b. Signature	
13d. Name Jeff Clarke – AD02		13e. Date (dd/mmm/yyyy) 29 Jan 2015		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mmm/yyyy)	

Installer Responsibilities

This certificate does not constitute authority to install.

Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.

Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.

M82

CARGO BASKET ASSEMBLY - COMMON

AS350 XL

General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

Bell 206L/407 – Right side only

69810, Revision 3 – Standard Low Mounted Basket
94510, Revision 0 – Extra-Wide Low Mounted Basket
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket
76610, Revision 0 – High Mounted Ski Basket

Eurocopter AS350/AS355 – left or right

77610, Revision 1 – Short Basket
76410, Revision 3 – Medium Basket (left or right)
78410, Revision 2 – Long Basket
→ 94010, Revision 0 – Extra Large (ski) Basket

Robinson R44 – left or right

90610, Revision 0 – Standard Basket (left or right)

Bell 206B – right side only

80210, Revision 0 – Short Basket
80310, Revision 0 – Medium Basket
81110, Revision 0 – Long Basket

Bell 429 – right or left

95911, Revision 0 – Standard Basket

Bell Medium – left or right

75111, Revision 0 – Standard Basket
95511, Revision 0 – Extra Large (ski) Basket

MD600

82811, Revision 0 – Standard Basket

Options

70405, Revision 3? – Lid Walkway

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

Work Order: 2015-11

Date Open: 23 JAN 2015

1. Lid Assembly

- a. Install lid bumpers on bottom.
 - i. Fill bumper holes with RTV silicone sealant.
 - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
 - i. Locate placard on bracket.
 - ii. Drill #30 through placard and bracket, using holes in placard.
 - iii. Remove placard and de-burr holes in placard and on bracket.
 - iv. Locate placard on bracket, and cleco in place.
 - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
 - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
 - ii. Pull tread plate from stock. Shear tread plate to length.
 - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
 - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
 - v. Mark and drill #30 holes:
 - 1. 0.25" from edge of tread plate, centre on cross members (0.38")
 - 2. 0.25" from edge of tread plate, middle of each walkway stringer
 - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
 - vii. De-burr holes in lid tubes.
 - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
 - ix. Set tread plate in place, secure with clecos if necessary.
 - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

2. Body Assembly

- a. Install attachment fittings
 - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
 - ii. Run 3/8-24 tap into attachment lugs to clear threads.
 - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
 - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
 - 1. 90610 (Robinson R44) basket only:
 - a. Install 1 fitting 906?? in lower forward attachment lug only.
 - b. Install 3 96710-01 fittings in remaining locations.
 - v. Torque to ??

- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
 - i. Locate 94621-01 Brace over aft cross tube cutout
 - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
 - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

3. Hinge Installation

- a. Prepare hinge.
 - i. Cut hinge to length:
 - 1. 776, 906 – 54"
 - 2. 751, 803 – 70"
 - 3. 698, 764, 945 – 72"
 - 4. 784 – 90"
 - 5. 940, 946, 959 – 95"
 - ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
 - i. Locate hinge on basket (standard baskets)
 - 1. centre fore/aft
 - 2. 0.15" – 0.18" up from bottom edge
 - ii. Locate hinge on basket (extra wide baskets)
 - 1. centre fore/aft
 - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
 - iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
 - iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
 - v. Remove hinge and de-burr holes in hinge and basket rim.
 - vi. Cleco hinge to basket with 5/32 clecos.
 - vii. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations
- c. Install lid on basket
 - i. Locate lid on hinge (all baskets)
 - 1. center fore/aft
 - 2. 0.15" – 0.18" down from top edge
 - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
 - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
 - iv. Remove hinge and de-burr holes in hinge and lid rim.
 - v. Cleco lid to hinge with 5/32 clecos.
 - vi. Install hinge with CherryMax rivets
 - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
 - 2. CR3213-5-02 aluminum rivets – all other locations

- d. Record PO of hinge and rivets on attached material tracking list.

4. Install Handle

- a. Install handle brackets.
- Set 84267-01 handle bracket on provisions in hoops, 2 places.
 - Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
 - Torque AN3 bolts to ??.
- b. Install handle
- Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
 - Grease two 36275-01 bushings with ??. Insert into bushings of handle assembly.
 - Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
 - On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
 - At first end, remove bolt and repeat step iv.
 - Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
 - Torque AN3 bolts to ??.
- c. Check handle
- Operate handle to ensure handle does not bind and springs hold handle in.
 - Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

CARGO BASKET ASSEMBLY - COMMON

Complete
(initial or SCA #)

AD02

6. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
 - i. Bolts are tight
 - ii. Rivets are installed correctly
 - iii. Handle operates correctly
 - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.

Work Order: 2015-11Date Opened: 23 JAN 2015

Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

1 of 2

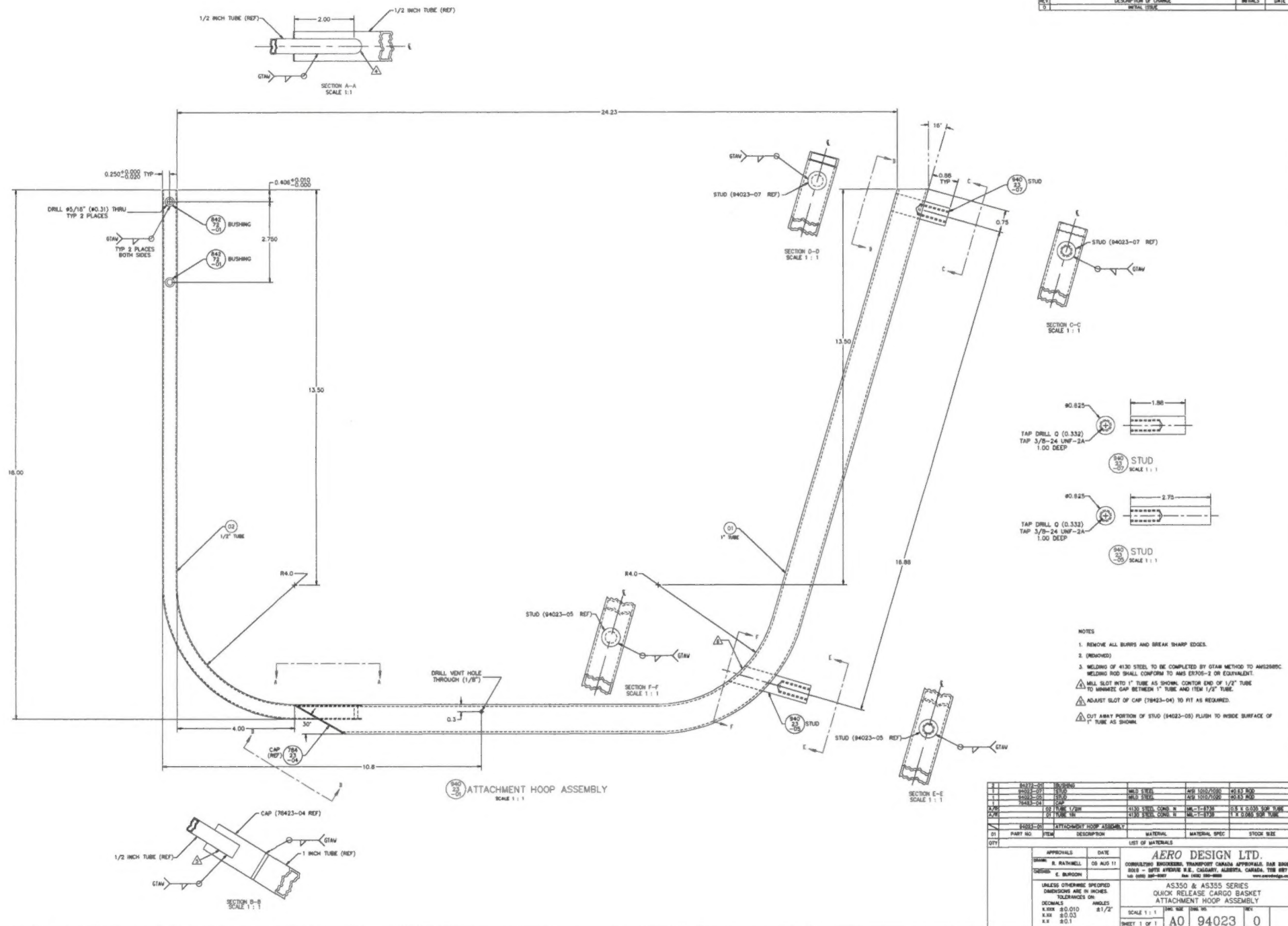
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>1</u>		94010-01	Cargo Basket Assembly	<u>S/N 94001-40</u>	
Step 1				<i>Lid Assembly</i>		
	. 1		94012-01	Basket Lid Assembly		<u>WO 2014-83</u>
Step 1.a.	. . 4		49205-14	Bumper	Argus Industries Bumper	<u>11010</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	<u>94001-40</u>
Step 1.b.	. . 1		94027-01	Placard	0.063 Sheet, 6061-T6 Aluminum	<u>94001-40</u> <u>WO 2015-03</u>
	. . 4		CR3213-4-02	Cherry Rivet		<u>14084</u>
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	<u>13066</u>
	. . A/R		CR3213-4-02	Cherry Rivet		<u>14048</u>
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 2				<i>Basket Assembly</i>		
Step 2.a.	. 1		94011-01	Basket Body Assembly		<u>WO 2014-83</u>
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	<u>12089</u>
	. . 8		AN960-616	Washer		<u>13084</u>
Step 3				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	95"	<u>14091</u>
	. 8		CR3523-5-02	Cherry Rivet		<u>14080</u> <u>14086</u>
	. A/R		CR3213-5-02	Cherry Rivet		<u>14094</u>
Step 4	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	<u>WO 2015-02</u>
	. . 4		AN3-11A	Bolt		<u>14001</u>
	. . 8		NAS1149F0363P	Washer		<u>14048</u>
	. . 4		MS21044N3	Nut		<u>13064</u>

Work Order: 2015-11Date Opened: 23 JAN 2015Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Assembly

2 of 2

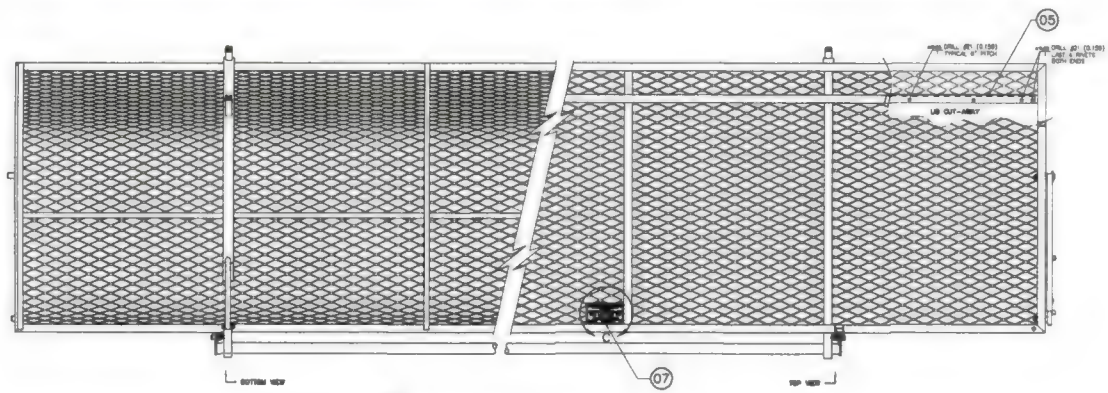
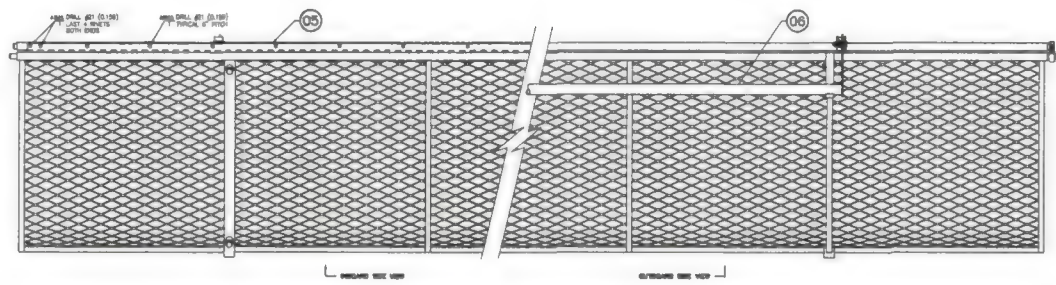
Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	.. 1		84261-01	Handle Assembly		
	.. 2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	13085
	.. 2		36275-01	Bushing	Brass, 5/16" Dia	2014-63
	.. 2		AN3-12A	Bolt		13084
	.. 4		NAS1149F0363P	Washer		14018
	.. 2		MS21044N3	Nut		13084
Step 5				Lid Brace Installation		
	. 1		36280-01	Brace Assembly	PO#	wo 2014-63
	. 1		AN3-15A	Bolt		13084
	. 1		AN3-17A	Bolt		13084
	. 2		AN970-3	Washer		13084
	. 3		NAS1149F0363P	Washer		14018
	. 2		MS21044N3	Nut		13084
Step 6				Inspection	None	

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

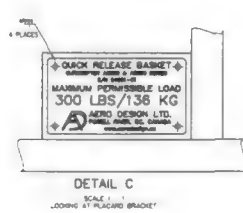
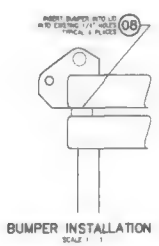
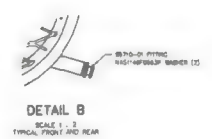
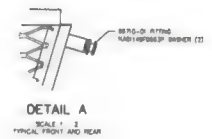
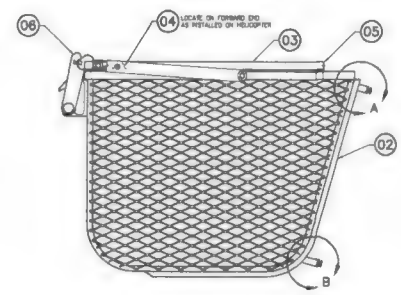


2015-11

REVISION	DESCRIPTION OF CHANGE	DATE
1	CHANGE FROM BLACK AND ALUMINUM FINISH TO ANODIZED ALUMINUM FINISH	15/07/2014
2	CHANGE FROM BLACK AND ALUMINUM FINISH TO ANODIZED ALUMINUM FINISH	15/07/2014



94010 CARGO BASKET ASSEMBLY - RH



NOTE
1. ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

QTY	PART NO.	POIN.	DESCRIPTION	MATERIAL	MATERIAL SPEC.	STOCK SIZE
1	94010-01		CARGO BASKET ASSEMBLY			
1	94010-02		QUICK RELEASE BASKET			
1	94010-03		QUICK RELEASE BASKET			
1	94010-04		QUICK RELEASE BASKET			
1	94010-05		QUICK RELEASE BASKET			
1	94010-06		QUICK RELEASE BASKET			
1	94010-07		QUICK RELEASE BASKET			
1	94010-08		QUICK RELEASE BASKET			
1	94010-09		QUICK RELEASE BASKET			
1	94010-10		QUICK RELEASE BASKET			
1	94010-11		QUICK RELEASE BASKET			
1	94010-12		QUICK RELEASE BASKET			
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1	94010-100		QUICK RELEASE BASKET			

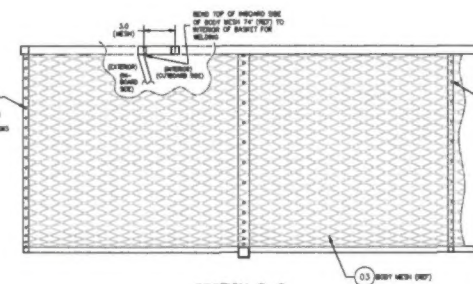
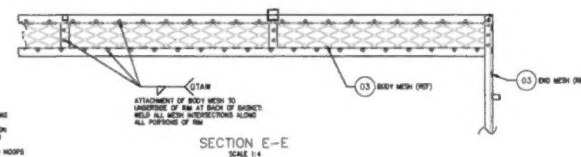
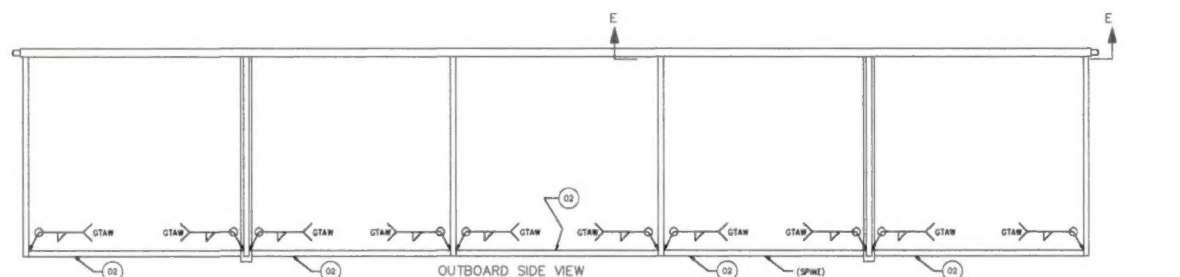
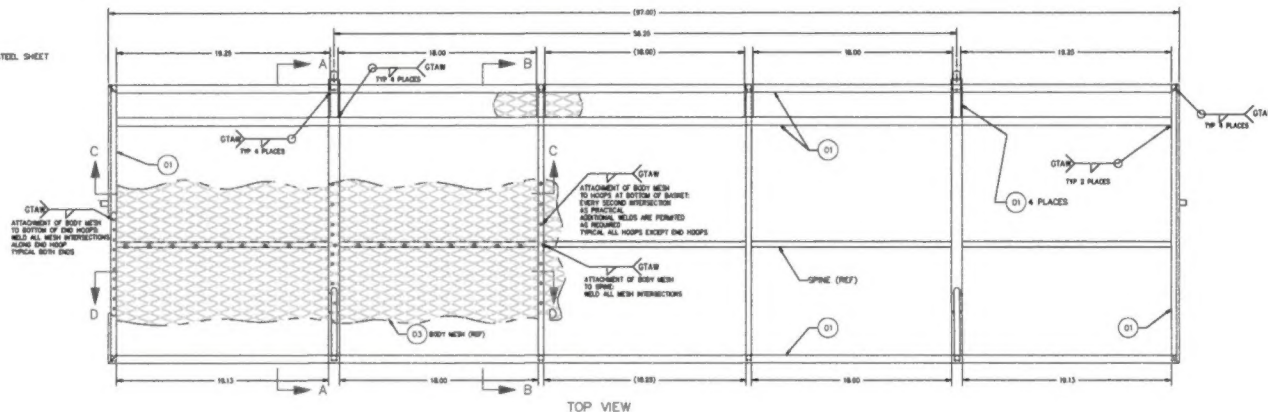
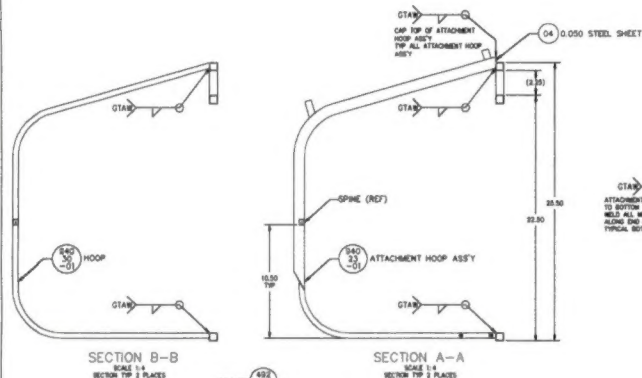
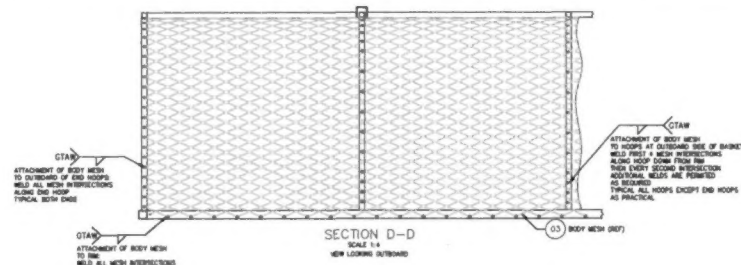
AERO DESIGN LTD.
 6888A MALABOR ROAD
 PORTER, BRITISH COLUMBIA, CANADA V6C 2G3
 TEL: 604 681 8888
 WWW.AERODESIGN.CO

EUROCOPTER AS350 & AS355 SERIES
QUICK RELEASE CARGO BASKET
BASKET ASSEMBLY (EXTRA LARGE)

SCALE 1:1 SHEET 1 OF 1
 94010 1

2015-11

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
01	INITIAL ISSUE		

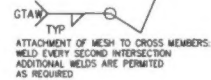
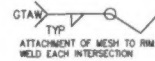


- NOTES:
- REMOVE ALL BURRS AND BREAK SHARP EDGES.
 - PROVIDE TO WELDING: DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
 - WELDING OF 4330 STEEL TO BE COMPLETED BY GTAW METHOD TO AHS BASIC. WELDING ROD SHALL CONFORM TO EXXOS-5 OR EQUIVALENT.
 - FINISH: THOROUGHLY CLEAN AND POWDER COAT BASKET WELDED ASSEMBLY.

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL/NOTE	MATERIAL SPEC	STOCK SIZE
	04	STEEL SHEET				
	03	MESH				
	01	SPACER				
	02	HOOP				
	02	ATTACHMENT HOOP				
	02	SQUARE TUBE	4130 STEEL COMB. IN	1/2" x 1/2" x 1/2"	0.5 x 0.035 SQ. TUBE	
	02	SQUARE TUBE	4130 STEEL COMB. IN	1/2" x 1/2" x 1/2"	0.75 x 0.035 SQ. TUBE	
	01	BASKET BODY ASSEMBLY				

APPROVALS	DATE	AERO DESIGN LTD.	
DESIGNED BY: R. BATHWELL	03 AUG 11	CONVEYOR/ENCLOSURE/TRANSPORT CANADA APPROVALS: DAB 6800	
CHECKED BY: E. BURTON		8810 - WEST AVE. S.E., CALGARY, ALBERTA, CANADA T2C 8P7	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES.		TOLERANCES ON:	
LINEAR	±0.010	ANGLES	±1/2°
R.A.	±0.03		
R.A.	±0.1		
SCALE: 1:4		SHEET 1 OF 1	
A0 94011		0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		



BOTTOM VIEW

02 MES



DRILL 1/2" THROUGH OUTBOARD SIDE OF TUBE
INSERT SPACER FULLY AND WELD IN PLACE
DRILL NO. 9 (0.196) THROUGH AFTER WELDING
TYPICAL BOTH ENDS

END VIEW

[illegible]

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES
2. PRIOR TO WELDING, DRILL 1/16" VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
3. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2689C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
4. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID WELDED ASSEMBLY.

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	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY			
	DECIMALS: X.XXX ± 0.010 X.XX ± 0.03 X.X ± 0.1		ANGLES: $\pm 1/2^\circ$			
	SCALE 1: 4 SHEET 1 OF 1		DIM. CODE A1	DIM. NO. 04012	REV. 0	

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		

NOTES

- ENGRAVE 0.007 DEEP AS FOLLOWS:
"QUICK RELEASE BASKET" - 0.125 HIGH
"EUROCOPTER AS350 & AS355 SERIES" - 0.080 HIGH
"S/N 94001-XX" - 0.080 HIGH
"MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
"300 LBS/136 KG" - 0.200 HIGH
"AERO DESIGN LTD." - 0.125 HIGH
"CALGARY, ALBERTA, CANADA" - 0.080 HIGH
"403-250-8027" - 0.080 HIGH

DRILL #30 (0.129)
4 PLACES



01 PLACARD

94027-01	01	PLACARD	6061-T6 ALUMINUM	QQ-A-250/11	0.063 SHEET
PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE

LIST OF MATERIALS

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	DRAWN: R. RATHWELL		OCT 3, 2011					
	CHECKED: E. BURGAIN				EUROCOPTER AS350 & AS355 SERIES LARGE QUICK RELEASE CARGO BASKET PLACARD			
	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2" X.XX ±0.03 X.X ±0.1							
SCALE 1 : 1		DWG. SIZE A1	DWG. NO. 94027	REV. 0				
SHEET 1 OF 1								

Aero Design

Parts Distribution Sheet

Description: Basket Assembly Kit

WO# _____

[illegible]